



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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D2652

Job Sheet 184767



Part No: D2652

Job Qty: 200 ea

Part Name: Bushing



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/16/18

Job Tracking No:

Due Date: 11/2/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV A IPP Rev:B 02.06.13 Now machined in house. NG

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	250 Ea	11/2/18	11/2/18	0.00	0.00	Start Up Machining-1		JRD 11/10/18
100	Hardinge	250 pcs	11/2/18	11/2/18	0.00	9.20	Hardinge		" "
110	QC	250 pcs	11/2/18	11/2/18	0.00	0.00	QC2 Machining-5		" "
120	QC	250 pcs	11/2/18	11/2/18	0.00	0.00	QC8		" "
130	Packaging	250 pcs	11/2/18	11/2/18	0.00	0.00	Packaging3-1		NOV 05 2018
140	QC21-SA	250 Ea	11/2/18	11/2/18	0.00	0.00	QC21		NOV 05 2018

Part Op Descriptions: 100 - 1-TURN AS PER FOLIO FA252 & DWG D2652

DAG
21
9-50

NOV 06 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M303R0.500	303 Round Bar 0.500"	11.283 13.7500 ft (.055 ea) (0.0564)	90-Start up Operation	512721

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M303R0.500	14	57	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Bushing	0.600inches ± 0.010	0.610 0.590		
2	Bushing	0.060inches ± 0.005	0.065 0.055		
3	Bushing	0.305inches + 0.000 - 0.002	0.305 0.303		
4	Bushing	0.191inches + 0.005 - 0.001	0.196 0.190		
5	Bushing	0.500inches ± 0.010	0.510 0.490		
6	Bushing	0.030inches ± 0.010	0.040 0.020		
7	Bushing	20.000Degrees ± 0.010	20.010		

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐							
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval				
Description Work Order Deviation				Disposition							
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐		☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due		☐ Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter		FAULT CATEGORY ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes		☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center		☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence	
				OTHER : ☐							

				19.990
8	Bushing	0.010inches	+ 0.010 - 0.000	0.020 0.010

Plex 10/16/18 3:23 PM Dart.lajeunesse.marie

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QA Closed: _____ Date: _____

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